

6061-T6 Tube .625 X .065 wall

Work Order ID 76141

76141

Page 1

Monday, November 07, 2011 11:13:01 AM

Item ID: D2743

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crossbolt Spacer

Start Date: 11/7/2011 Start Qty: 100.00

100

Cust Item ID:

Required Date: 11/16/2011 Req'd Qty: 100.00

100

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan:

Date: 11-11-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2743

Rev B

0.00

100

100

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

1-TURN AS PER FOLIO FA202 & DWG D2743

FOLIO REV: HA

DWG REV: B

2-DEBURR AS REQUIRED

100 0 11/11/10

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

100 0 11/11/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76141

76141

Page 2

Monday, November 07, 2011 11:13:01 AM

Item ID: D2743 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crossbolt Spacer
 Start Date: 11/7/2011 Start Qty: 100.00 ***100*** Cust Item ID:
 Required Date: 11/16/2011 Req'd Qty: 100.00 ***100*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		A.A 11/11/10		100	0		
130 *130* Skidtubes	1- Clean crossbolt spacer with ultra bright aluminum cleaner Memo	0.00 0.00				100	0	BE 11-11-10	
160 *160* Packaging Packaging	Identify as per dwg & Stock Location LG Memo ***STOCK IN SKIDTUBE CELL***	0.00 0.00				100	0	BE 11-11-10	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 76141***76141***

Page 3

Monday, November 07, 2011 11:13:01 AM

Item ID: D2743

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crossbolt Spacer

Start Date: 11/7/2011 Start Qty: 100.00

100

Cust Item ID:

Required Date: 11/16/2011 Req'd Qty: 100.00

100

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00


170

QC

Memo

0.00

Quality Control

11/11/21 211-11-18
(100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Monday, November 07, 2011 11:13:06 AM

Page 1

Work Order ID: 76141

76141

Parent Item: D2743

D2743

Parent Item Name: Crossbolt Spacer

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP E05.04.13Reformat; removed tumble and deburr stepKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.625W.065

Purchased

No

100

f

30.3340

0.2667

28.07368

**

28.083'

SL u/a/10

M6061T6T0 625W 065

6061-T6 RD Tube .625 x.065W

Location

Loc Qty

Loc Code

MAT014

30.334

117598

28.334

117890

2

118 390

25.750'

2.000'

0.333'

W/O:		WORK ORDER CHANGES					
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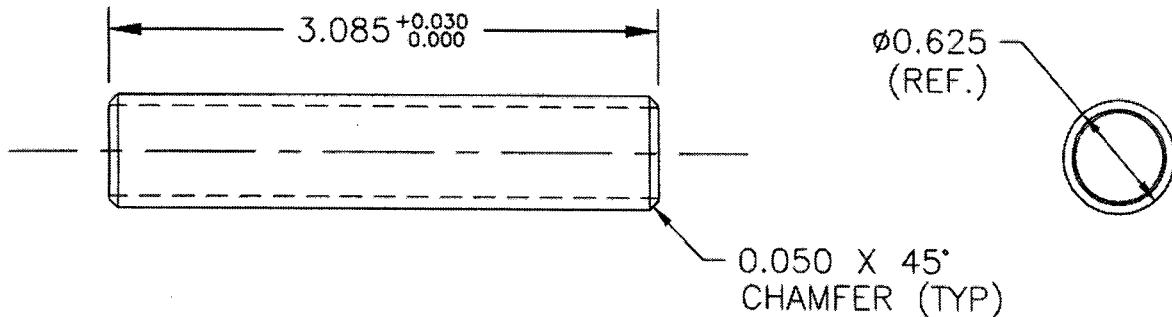


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>KE</i>	DRAWING NO. D2743	REV. B SHEET 1 OF 1
DATE 98.12.08		TITLE CROSS BOLT SPACER	SCALE 1:1
A	98.04.16	NEW ISSUE	
B	98.12.08	3.085 WAS 3.060	

RELEASED
98.12.16 DS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 76141

11-11-07



MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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